

Work Order ID 70288

Thursday, June 02, 2011 1:20:23 PM

Page 1

Item ID: D412-704-011

Accept

Revision ID:

Item Name: Copilot Emergency Cargo Release

Setup Start

Stop

Start Date: 6/9/2011 Start Qty: 3.00

Required Date: 6/17/2011 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-704-011CHG001

8 u66603

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/6/3 sl p

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 u66603

70

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-704-011 Location: 3/ PPP Rev: B

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00



Setup Start



Stop



Cust Item ID:

Customer:



11/6/3 SP



11/6/6 HJ
MF
11-06-03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Picklist Print

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Page 1

Work Order ID: 70288

Parent Item: D412-704-011

Parent Item Name: Copilot Emergency Cargo Release

Start Date: 6/9/2011

Required Date: 6/17/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:B105.01.28 Hardware added to Step 3 KJ/RF
IPP Rev:C105.12.21 Hardware removed on Step 3 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3207-2

Manufactured

No

120

Each

3.0000

1

3

Bracket

Location

Loc Qty

Loc Code

ST202

3

57562

3

D3207-5

Manufactured

No

120

Each

4.0000

1

3

Bracket

Location

Loc Qty

Loc Code

GA

4

46856

4

D3208-1

Manufactured

No

120

Each

2.0000

1

3

Doubler

Location

Loc Qty

Loc Code

ST202

2

64827

2

D3208-11

Manufactured

No

120

Each

21.0000

1

3

Filler

Location

Loc Qty

Loc Code

ST202

21

57563

6

67718

15

11/6/35

12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, June 02, 2011 1:20:20 PM

Page 2

Work Order ID: 70288

Parent Item: D412-704-011

Parent Item Name: Copilot Emergency Cargo Release

Start Date: 6/9/2011

Required Date: 6/17/2011

Start Qty: 3.00

Required Qty: 3.00

D3208-3
Pedal Mount Angle

Manufactured No

120 Each

8.0000

1 3

SP

Location

Loc Qty

Loc Code

ST202

8

68697

8

R

D3208-7
Filler

Manufactured No

120 Each

10.0000

1 3

SP

Location

Loc Qty

Loc Code

ST202

10

68698

10

R

D3208-9
Doubler

Manufactured No

120 Each

5.0000

1 3

SP

Location

Loc Qty

Loc Code

ST202

5

57754

5

I

D3214-1
Placard

Manufactured No

120 Each

1.0000

1 1

SP

Location

Loc Qty

Loc Code

ST202

1

64826

1

I

D412-704-041
Pedal Assembly (205/212/214/412)

Manufactured No

120 Each

0.0000

1 3

B70124 (12) SP

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Thursday, June 02, 2011 1:20:20 PM

Page 3

Work Order ID: 70288

Parent Item: D412-704-011

Parent Item Name: Copilot Emergency Cargo Release

Start Date: 6/9/2011

Required Date: 6/17/2011

Start Qty: 3.00

Required Qty: 3.00

D412-704-045

Manufactured

No

120

Each

2.0000



1

3

sf



Cable Assembly (212/214/412)

Location

Loc Qty

Loc Code

ST223

2

69420

2

MS21919-DG5

Purchased

No

100

Each

40.0000



4

1

12

11/6/3

sf



Clamp

Location

Loc Qty

Loc Code

ST306

40

117395

40

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

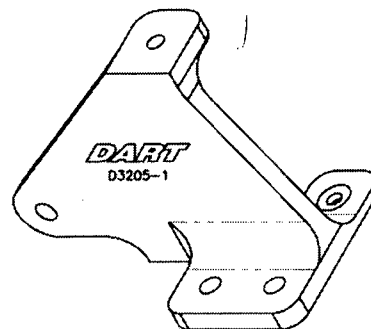
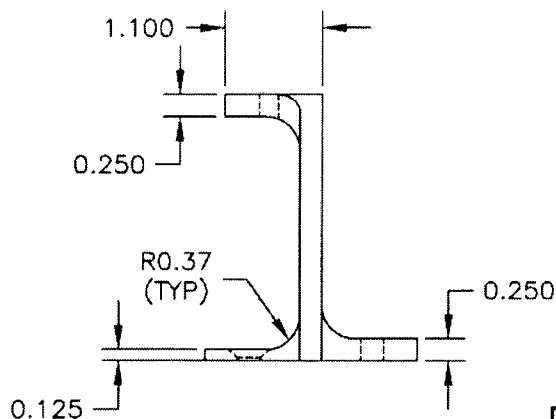
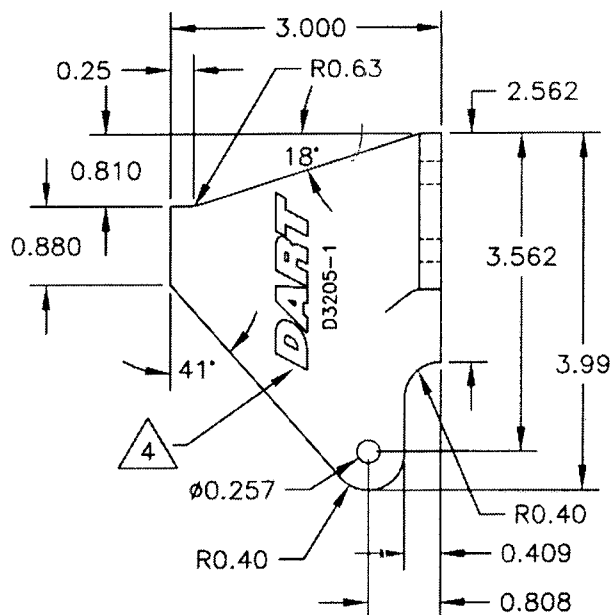
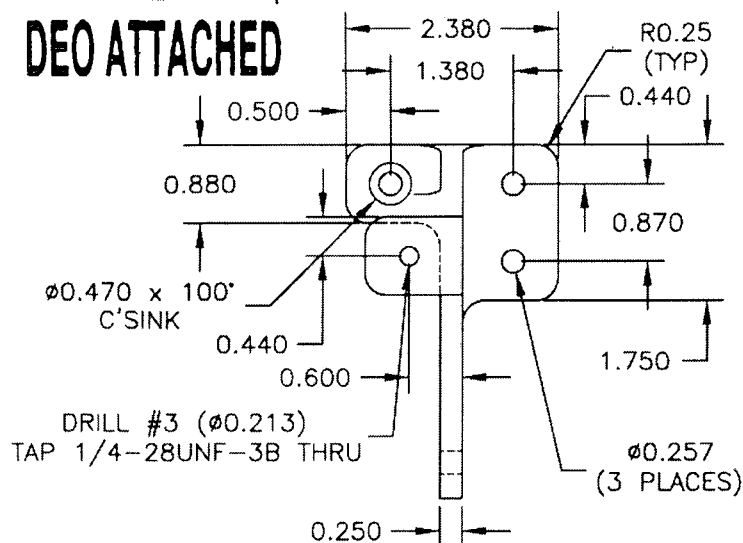
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3205	REV. A SHEET 1 OF 2
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
R 1040405 #

DEO ATTACHED



D3205-1 PEDAL BRACKET

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

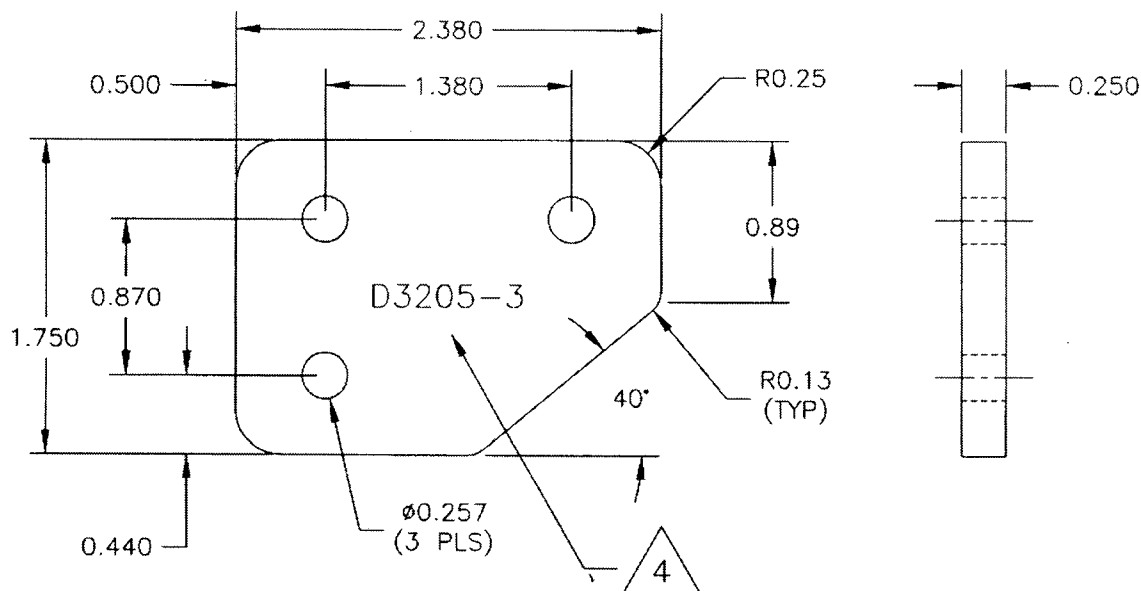
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3205	REV. A
DATE 04.01.27	TITLE BRACKET	SHEET 2 OF 2	
		SCALE 1:1	

RELEASED
04.01.27

DEO ATTACHED



D3205-3 BACK PLATE

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

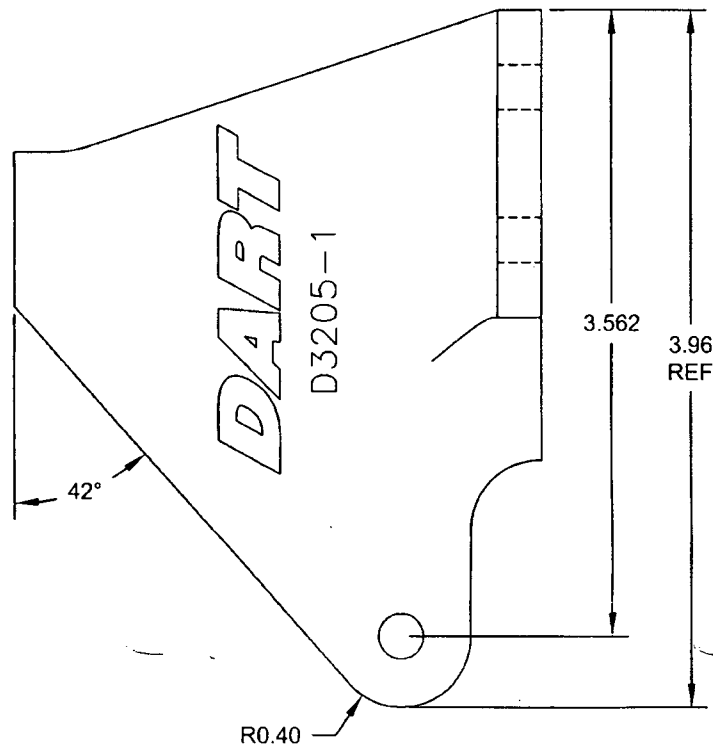
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

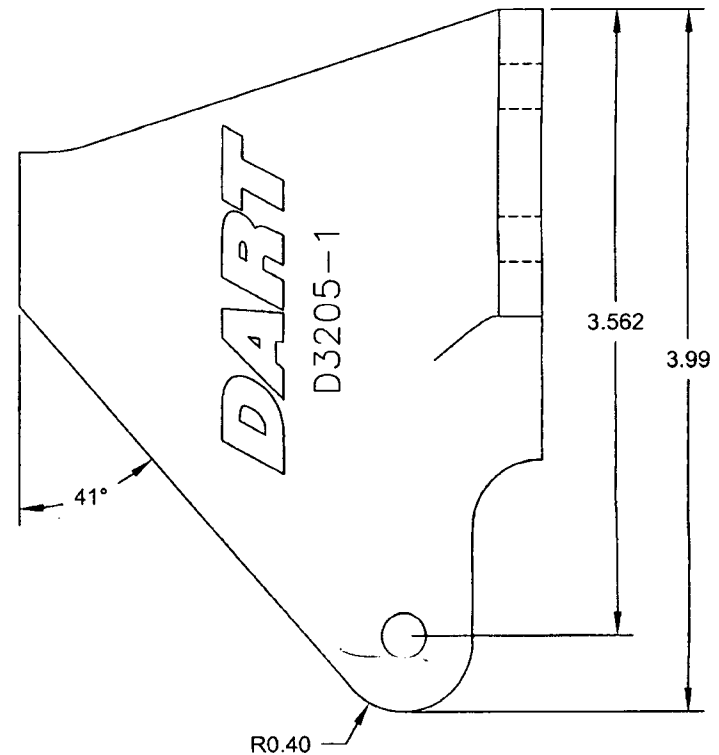
DRAWING NO. D3205	TITLE BRACKET	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3205-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.12.01	DATE 08.12.01	DATE 08/12/01	DATE 08/12/01		DATE 08.12.01		

SHEET 1 MODIFY D3205-1 AS SHOWN:

IS:



WAS:



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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Qty -043	Qty -045	Part Number	Description
X					D412-704-011	COPILOT'S EMERGENCY CARGO RELEASE KIT (210/212/214/412)
	X				D205-704-013	COPILOT'S EMERGENCY CARGO RELEASE KIT (205)
1	1	X			D412-704-041	PEDAL ASSEMBLY (205/210/212/214/412)
	1		X		D205-704-043	CABLE ASSEMBLY (205)
1				X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
		1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
		1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
		1			D3205-3	BACK PLATE (OR ECM 999709-5)
		1			D3206-1	PEDAL ARM (OR ECM 999704-1)
	1				D3207-1	BRACKET
1					D3207-2	BRACKET
	1				D3207-3	BRACKET
1					D3207-5	BRACKET
1	1				D3208-1	DOUBLER (OR ECM 999709-1)
1					D3208-11	FILLER
1	1				D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1				D3208-5	MOUNT ANGLE
1	1				D3208-7	FILLER (OR ECM 999709-3)
1					D3208-9	DOUBLER
		1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1				D3214-1	PLACARD (OR ECM 999712-1)
			1		D3217-1	CABLE
				1	D3217-3	CABLE
			1	1	D3257-1	FITTING
			1	1	D3258-1	ANGLE BRACKET
		1			AN315-4R	NUT
		5	2	2	AN960JD10	WASHER
		4	2	2	AN960JD10L	WASHER
		11			AN960JD416	WASHER
		3			AN960JD416L	WASHER
			3	3	NAS509-3	NUT
		3	2	2	MS21042L3	NUT (OR MS21042-3)
		5			MS21042L4	NUT (OR MS21042-4)
4	4				MS21919DG5	CLAMP
		1			MS24694-S102	SCREW
	2				MS35489-10	GROMMET
			1	1	AN3-5A	BOLT
		2			AN3-6A	BOLT
		1			AN3-10A	BOLT
			1	1	AN3-13A	BOLT
		1			MS9519-10	BOLT
		1			AN4-10A	BOLT
		2			AN4-12A	BOLT
		1			AN4-13A	BOLT

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Revision: B
 Date: 07.08.10